

Work Order ID 70481

Thursday, June 09, 2011 3:00:25 PM

Page 1

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 6/9/2011 Start Qty: 12.00

Required Date: 6/20/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan:

QC:

Date: 6/9/11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

304.063

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control



Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



B 11-6-10

24

B 11-6-10

count
724

8 u66113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr if necessary. Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3. Form Joggle as per Dwg D3537 on brake using Jig DT8158

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Ensure joggle as per dwg D3429

0.00

0.00

150



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat
m118196 Weld hardcoat as per Dwg D3437

0.00

0.00

SB 11/06/13

8 11/06/13

counts
x24

x22

11-07-17 JBL/E

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Item ID: D3537-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 6/9/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

11.07.28

22



170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11.07.28 (22)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

9:30

9:00

22x4 m-l 11/02/02

117338

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

22 x 4 11/08/02

200

Identify as per dwg & Stock Location: F-P 16

0.00



Packaging

Memo

0.00

Packaging

22x 4 m-L 11/08/02

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/02

11-08-2 (22)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, June 09, 2011 3:00:32 PM

Page 1

Work Order ID: 70481

Parent Item: D3537-3

Parent Item Name: Wearpad



Start Date: 6/9/2011

Start Qty: 12.00

Required Date: 6/20/2011

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	121.1000	0.149	1.882105			



304/316 Sheet .063



B11-6-10



Location

Loc Qty

Loc Code

MAT020

121.1

117275

6.3

117653

114.8

117375

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 70451
Description: Wearpad		Part Number: D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.859	+/-0.010	5.854	X		V Bez	
3.500	+/-0.010	3.496	X		V	
1.965	+/-0.010	1.971	X		V	
2.795	+/-0.010	2.794	X		V	
3.625	+/-0.010	3.619	X		V	
0.220 x 0.380	+/-0.010	0.227 x 0.384	X		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-6-10	Date: 11/6/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
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SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

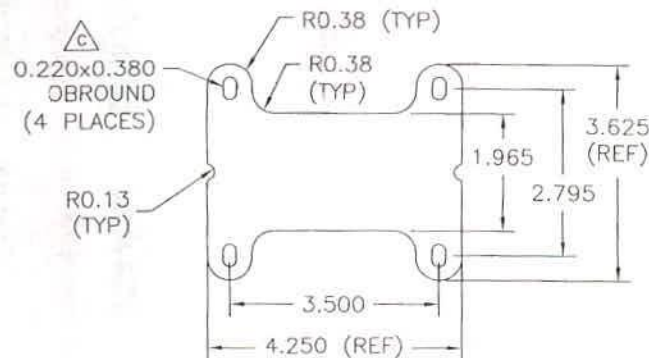
SUBJECT TO AMENDMENT

WITHOUT NOTICE

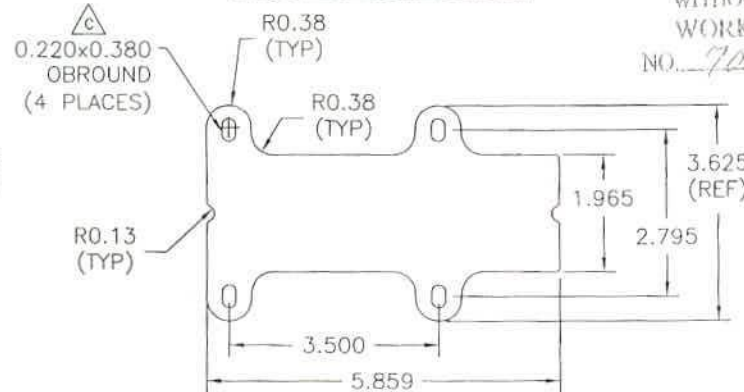
WORK ORDER

NO. 70451

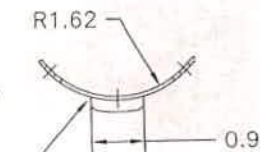
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

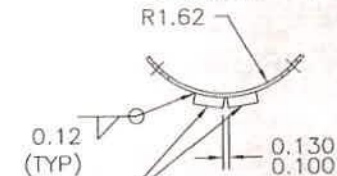


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

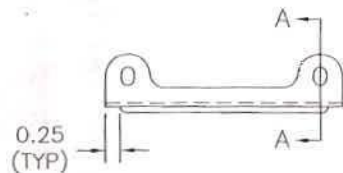
SECTION B-B



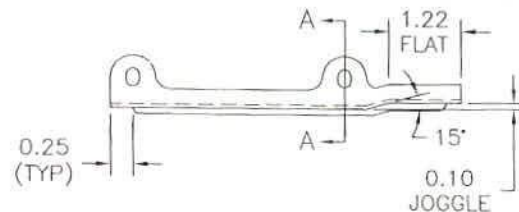
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08
PDR ELN
962

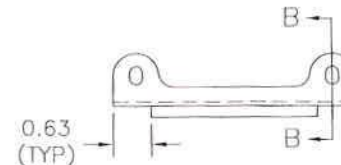
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



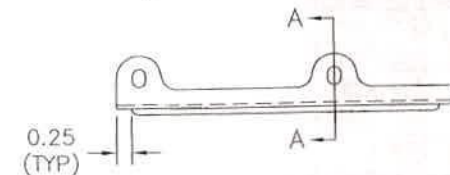
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	TITLE WEARPAD
		DART AEROSPACE USA, INC. PORT HADLOCK, MA
		DRAWING NO. D3537
		REV. C
		SHEET 1 OF 1
		SCALE 1:2

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